	er ID 115573 10, 2014 10:47:58 AM			*115	5573*						Page 1
Item ID: Revision ID:	D3574-1		A	Accept	*N900	040	100)* ፡	Setup Sta	ırt * N	S1*
Item Name: Start Date: Required Date:	Cabin Floor Protector 4/04/14	٠,٠			Cust Item I Customer:	D:			Sto	^{op} *N	S2*
Approvals:	Process Plan: QC:	Date: 4-7	-10	Tooling: SPC (Y/N):		nte:		I	Run Sta Sto	/ I/	R1* R2*
Sequence ID/ Work Center II	Operation Description		<i>f</i>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3574	Revision Nbr Rev B										
*105 *105* Purchasing Purchasing	ТО ТРІ	0: <u>2498</u> 5 per dwg:d3574 re		0.00				<u> </u>	L 1 410	37/14	23

3x 5014-8-13

0.00

0.00

115

115 Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

DQA:		Date:											DART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		Nork Orde	r update only		AEROSPACE
					DISPOSITION				AGAINST (DEPARTME	NT/PROCESS		
Work Orde	r:				·	ı		a::	C	_	Mator	La+	Cusinessins
Part N	0				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	\dashv	. Water Prod. Eng. Co		Engineering Quality
raitiv	·				Use-as-is			noforming	Finishing	_	Store/Packag		Other
NCR N	o				Suspected Unapproved		111011	Large Fab	Composite		Suppl		
Root			1	Desci	ription of work order update		Initial	Act	ion	Sign 8			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verifica	tion	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process		'											
Supplier						1							
Training													
Transport						l							
Unapproved		1		ĺ									
						FA	ULT CA	ΓEGORY					
Landir	ng Gear				General		_						_
,	Bending				Bend		Folio/F	Program	L	Outside	Dimensions	L	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Ur	der tolerance		Set-up
[Cracks				Broken/Damage/Defect		Hardwa	ire		Part Inco	orrect		Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified	Part Los	:/Missing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/l	Jnclear	Part Mo	ved.	L	Wrong Stock Pulled
ļ	Crushing				Countersink		Misalig	ned/off center		Position	ed Wrong		_
	Heat Tre	at			Cut Too Short		Mislabe	eled	[Power L	oss/Surge		Other
	Inspection	n Strip in	Tube		Drawing		Misrea	d	_				
	Marks/C	hatter			Drill Holes	$\begin{bmatrix} & & & & & & & & & & & & & & & & & & &$	Off-set						
	Turning S	Sequence	:		Finish		Out of	Calibration					
	Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence					

4										<u> </u>	
Work Ord Thursday, July				*11 <i>5</i>	5573*						Page 2
Item ID: Revision ID:	D3574-1			Accept	*N900	040	100)*	Setup S	tart *\	IS1*
Item Name:	Cabin Floor	Protector							S	top *\	IS2*
Start Date: Required Date Reference:	4/04/14 : 4/04/14	Start Qty: 3.00 Req'd Qty: 3.00	*3*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	_]	Run St	art *N	IR1*
	QC:	•	Date:	SPC (Y/N):	Da	ate:			Si	*N	IR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		QC6- Inspect dimensions	s to drawing	0.00						DAS	DAS
195 QC Quality Control		Memo		0.00			•	3		9-89	38 9-89_ <i>1</i> 4-
130				0.00							
120 Small Fab		Small Fab Memo		0.00							
Small Fab		Deburr if ne	cessary.	1							

Small Fab 140 *14**0***

QC5- Inspect part completeness to step on W/O Memo

Quality Control

DQA:		·	Date:											ΔRT
						WORK ORDER NON	-CC	ONFO	RMANCE / UPE	DATE		_	_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Ora						Rework	1		Skid-tube	Crosstube	1	Water Jet	Engir	neering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR I	۱o. ِ	<u></u>				Suspected Unapproved]		Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	1	nitial	Actio	n	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	n QC	Inspector
Design						•								
Doc/Data					*									
Equip/Tooling														
Handling/Pre		٠.												
Material														
Operator		»											İ	
Offset/Setup														
Process	_													
Supplier														
Training Transport													-	
Unapproved					<u> </u>									
опаррточес				I	L		FA	ULT CA	TEGORY			!:		
Landi	ng (Gear				General		1						
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressur	re/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	•		Over/Under	tolerance	Set-up)
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	εί	Tempe	rature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	tions Incomplete/Un	clear	Part Moved		Wrong	Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					·
		Wave/Tw	ist in Tub	oe_		Fit/Function		Out of	Sequence					

115573

Page 3

Work Order ID 115573 Thursday, July 10, 2014 10:47:58 AM **Item ID:** D3574-1 **Revision ID: Item Name:** Cabin Floor Protector **Start Date:** 4/04/14 Start Qty: 3.00 Required Date: 4/04/14 Req'd Qty: 3.00

QC:

N900040100

Stop

Cust Item ID: Customer:

Reference:

Approvals:	

Process Plan:

Date: Date:

Tooling: SPC (Y/N):

Accept

Date: Date:

Run Start Stop

Sequence ID/ **Work Center ID** 150

Operation **Description** Identify as per dwg & Stock Location:

Set Up/ Run Hours 0.00

Tool ID

Plan Code

Accept Qty

Reject Qty

Setup Start

Reject Number Stamp

Insp.

150

Packaging **Packaging**

Memo

0.00

Tool#

160

QC21- Final Inspection - Work Order Release

0.00

160 QC

Memo

0.00

MLJ 14-08-25

Quality Control

DQA:	CANO	Date:	<u> </u>	<u> 8 2 </u>				•				DART
QA Closed:	axyl	Date:	14-	8-2	WORK ORDER NON	l-C(ONFO	RMANCE / U		ork Order up	odate only	AEROSPĀCE
Work Order:	1153		•	0 2	DISPOSITION					PARTMENT		
Part No	. <u>D35</u> -	74-1			Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- 4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update		nitial		tion	Sign &		
Equip/Tooling	Date	Step (50	Qty	emp on the	or non-conformance ing packaging loye drop hot glue panel and damage finish operate their	Q=	DAS 16 9-89 20-72 VZ 26.		no replace	JM 1408-21	Verification DAS 38 9-89 74/03/21	QC Inspector DAS 16 9-89 [4(08/2)
						FA	ULT CA	TEGORY				
Landing	Gear Bending Centre No Cracks Crimp/Kir Cuffs				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination		Grain Hardwa Inspect Instruc	ion Incomplete/U tions Incomplete/U		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved	tolerance	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled
	Crushing Heat Trea Inspection Marks/Ch Turning S	n Strip in natter equence	!		Countersink Cut Too Short Drawing Drill Holes Finish		Mislabo Misrea Off-set Out of	d Calibration		Positioned V Power Loss/ 人 ひみ		Other
i l	Wave/Tw	ist in Tul	be	ı	Fit/Function	1	IOut of	Sequence				

Page 1

Work Order ID: 115573

115573

Parent Item:

D3574-1

D3574-1

Location

MAT019

Parent Item Name: Cabin Floor Protector

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/
Item Name

Replacement Mfg/ Item ID

Purch

Bin **Primary** Item Location Last Location

Route Seq ID

Unit of Measure

Qty on Hand

Qty per Kit Total

**

Qty

Qty Date Issued

Status Issued

MLEXS.125-F60029-04

Purchased

No

124866

m126425

m127934

m128746

sf

3,193.525

77 L

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Loc Qty 3193.525 106 160.925 699.6

2227

Loc Code

m 129759

CLIY10>/14

DQA:			Date:										*DAR	T
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		/ork Order up	date only	AEROSPAC	; Ē
			11)			DISPOSITION				AGAINST D	EPARTMENT,	PROCESS		
Work Orde	er: -		····			Dawark	ı İ		Skid-tube	Crosstube	٦	Water Jet	Engineering	٦
Part N	lo.					Rework Scrap	1	1	Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	-					Use-as-is		Thern	noforming	Finishing	Rec/Stoi	re/Packaging	Other	_
NCR N	lo. <u>-</u>					Suspected Unapproved]		Large Fab	Composite		Supplier		╛
Root					Desc	ription of work order update	П	nitial	Acti	ion	Sign &	A.O.		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	n QC Inspector	
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre							ļ				1			
Material	_						1							
Operator	\blacksquare													
Offset/Setup	\blacksquare													
Process														
Supplier														
Training	\Box													
Transport	Щ													
Unapproved			ļ					LUT CA	FECORY					
							FA	OLI CA	TEGORY					
Landi						General Bend	Γ	ا دماند ۱۰	Program	·	Outside Dim	onsions	Pressure/Forced	
		Bending	at Canaa		-	BOM/Route	\vdash	Grain	Togram	-	Over/Under		Set-up	
	\vdash	Centre No Cracks	or concer	ILITE		Broken/Damage/Defect	\vdash	Hardwa	aro.	<u> </u>	Part Incorre		Temperature/Cure	۵
·	Н		nk/Binnla	/\4/2\40		Burrs	-	4	ion Incomplete/Un	ogualified	Part Lost/M		Weld	_
	-	Crimp/Kin	пк/кірріе	yvvave	-	Contamination	-	4	tions Incomplete/U		Part Moved	1331116	Wrong Stock Pulle	-d
	-	Crushing				Countersink	-	-	gned/off center	-	Positioned V	I Vrong		
		Heat Trea			-	Cut Too Short	\vdash	Mislabe	•	· -	Power Loss/	-	Other	
	H	Inspectio		Tuba	-	Drawing		Misrea		L		0-	1	
1	 	Marks/Cl		iune	-	Drill Holes	\vdash	Off-set						
	\vdash	Turning S				Finish	—	4	Calibration		···	· · · · · · · · · · · · · · · · · · ·		
	\vdash	Wave/Tw	-			Fit/Function		-1	Sequence					

DART AEROSPACE LTD	Work Order:	112273
Description: Cabin Floor Protector	Part Number:	D3574-1
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First A	Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001		1,		J	Fl. m - Di
7.37	+/-0.030	7.37	 		7	3km-01 3km-06
10.75	+/-0.030	10.75	/		1	3 KV to 1
11.00	+/-0.030	11.00			 	
15.25	+/-0.030	15.25				
25.87	+/-0.030	25.97				
39.75	+/-0.030	39.75	<u> </u>			
44.75	+/-0.030	44.75	 			
49.11	+/-0.030	49.11	//			*
51.11	+/-0.030	51.11	/			
53.51	+/-0.030	53.51				
63.50	+/-0.030	63.50				
65.25	+/-0.030	65.25	 			
		63,23				
10.75	+/-0.030	10.75	1			
11.06	+/-0.030	11.06				
14.75	+/-0.030	14.75	V			
25.50	+/-0.030	25.50				
25.75	+/-0.030	25.75				
26.00	+/-0.030	26.00	1			
32.87	+/-0.030	32.87)			
38.81	+/-0.030	38.81				
44.75	+/-0.030	44.75	7			
45.00	+/-0.030	45.00				
48.25	+/-0.030	48.25				
58.38	+/-0.030	58.36	1			
61.25	+/-0.030	61.25	/			
64.13	+/-0.030	(4.13	/			
64.63	+/-0.030	64,63	11			
66.50	+/-0.030	16.50				
7.50	+/-0.030	7.50	7		1	
9.50	+/-0.030	9,50	/		j	
10.38	+/-0.030	10.38				
10.88	+/-0.030	10.88	1		17	No.
14.50	+/-0.030	14.50	<u> </u>		- "	***

DART AEROSPACE LTD	Work Order:	1155 75
Description: Cabin Floor Protector	Part Number:	D3574-1
Inspection Dwg: D3574 Rev: B		Page 2 of 2

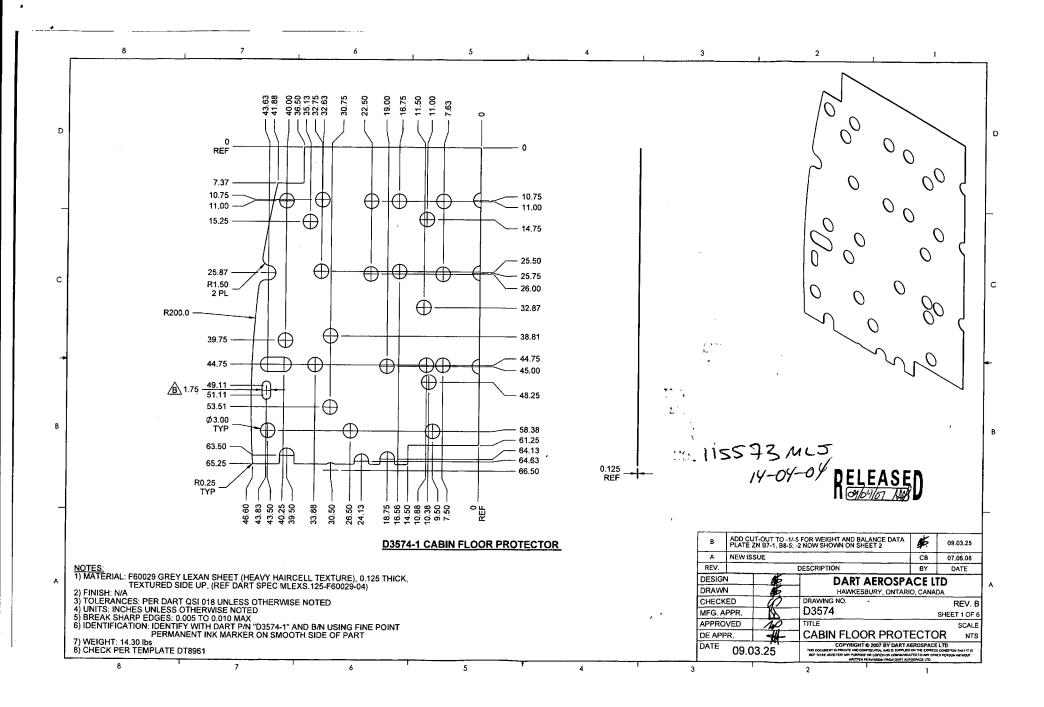
FIRST ARTICLE INSPECTION CHECKLIST

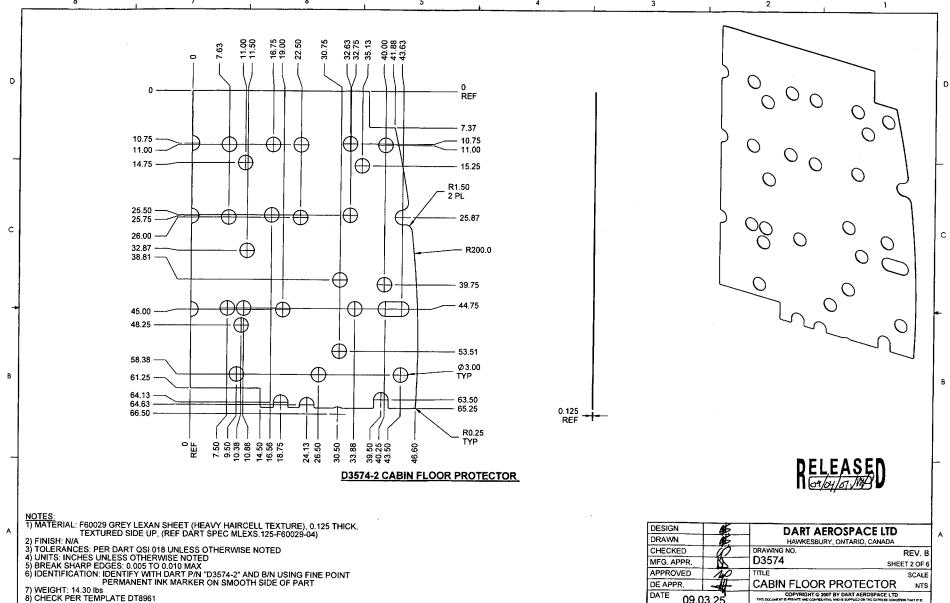
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	1		r	JKN-06
18.75	+/-0.030	18.75	//			
24.13	+/-0.030	24-13				
26.50	+/-0.030	26.50	1			
30.50	+/-0.030	30:50	1,			
33.88	+/-0.030	33.88				
39.50	+/-0.030	39.50	1			-
40.25	+/-0.030	40.25	1,			•
43.50	+/-0.030	43.50				
43.83	+/-0.030	43.83	1			
46.60	+/-0.030	46.60	1			
7.63	+/-0.030	7.63	/			
11.00	+/-0.030	11.00				::
11.50	+/-0.030	11.50				
16.75	+/-0.030	16.75	1			
19.00	+/-0.030	19,00	11			
22.50	+/-0.030	22.50				
30.75	+/-0.030	30.75	1	_		
32.63	+/-0.030	32.63	1			
32.75	+/-0.030	32.75				
35.13	+/-0.030	35,13	/			
36.50	+/-0.030	36.50	1.			
40.00	+/-0.030	40,00	7			
41.88	+/-0.030	41.84	7			· · · · · · · · · · · · · · · · · · ·
43.63	+/-0.030	43.63	7,		₹	
0.125	+/-0.010	6.125	DASS		V	JKM-01 "

				40	_		
Measured b	122	3	Audited by:	9-89	DAS 9	Prototype Approval:	N/A
Dat	=: 14/04/1 3	9	Date:	14/08/	2009	Date:	N/A

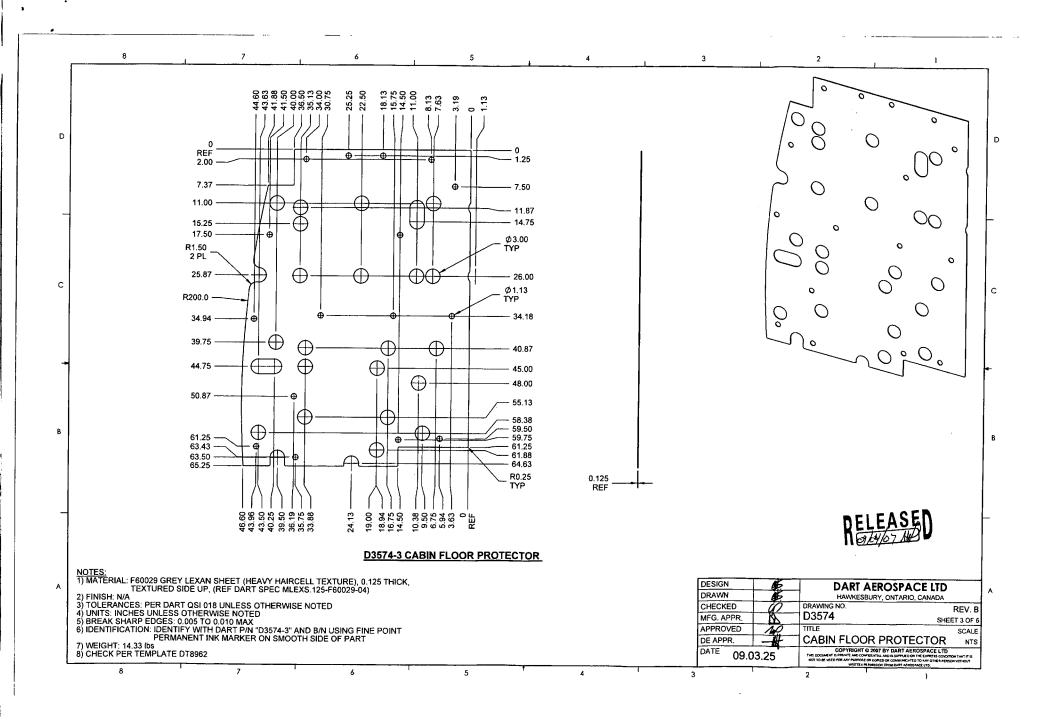
Date	Change	Revised by	Approved
08.02.28	New Issue	KJ//DD	
08.07.31	47.75 dimension removed	KJ/DD ,,	
09.05.15	Dimensions updated per Dwg Rev B	KJ 🛠	N/
	08.02.28 08.07.31	08.02.28 New Issue 08.07.31 47.75 dimension removed	08.02.28 New Issue KJ//DD 08.07.31 47.75 dimension removed KJ//DD

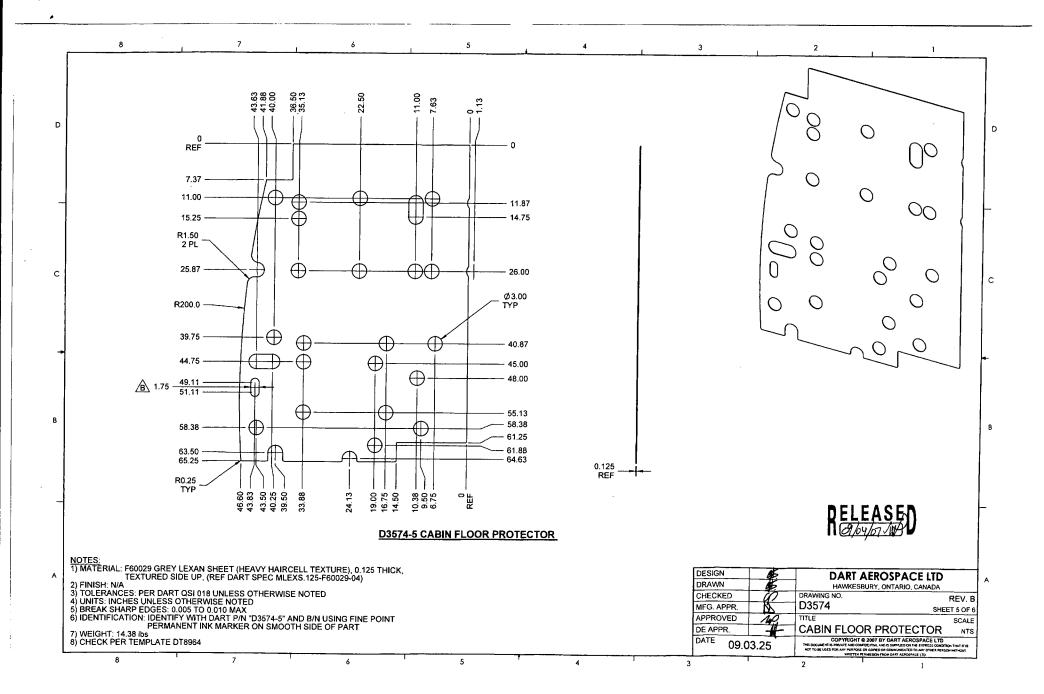


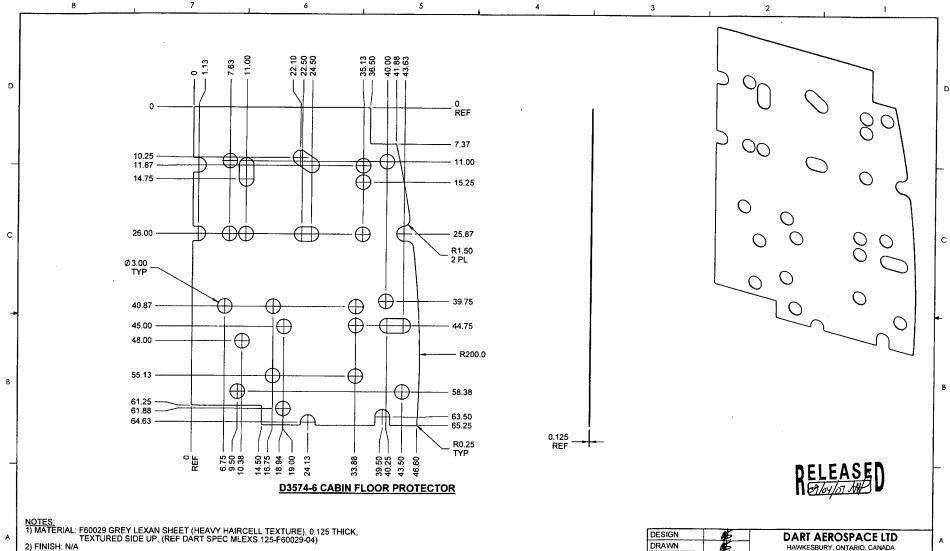


7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961

DESIGN	45	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN	DRAWN CHECKED						
CHECKED	0	DRAWING NO.	REV. B				
MFG. APPR.	12/2	D3574 _{SHE}	ET 2 OF 6				
APPROVED	140	TITLE	SCALE				
DE APPR.	-#	CABIN FLOOR PROTECTOR	NTS				
DATE 09.0	03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONCE NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO MY OTHER PERS					







2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965

DESIGN	45	DART AFROSPACE LTD	ART AFROSPACE LTD				
DRAWN	N						
CHECKED	00		REV. B				
MFG. APPR.	182	D3574 SHE	SHEET 6 OF 6				
APPROVED	100	TITLE	SCALE				
DE APPR.		CABIN FLOOR PROTECTOR	NTS				
DATE 09.0)3.25						



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24985

Purchase Order Date 7/14/2014 PO Print Date 7/14/2014

Page Number 1 of 8

Order From:

TPI INDUSTRIES INC. 148 RUE GOODFELLOW DELSON, QUEBEC J5B 1V4 CANADA VC-TPI001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FASSD

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

450-633-0484

TST Overland

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr		Description/ Mfg ID	Req Date/ CD Taxable	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments Delivery Comments		Promise Date	weasure		
1	115573	D3574-1 CABIN FLOOR PROTECTOR	8/13/2014	3.00	\$32.00 🖌	\$96.00
			Yes			
			8/13/2014		\sim	
	AS PER DWG D3574-1 REV.B B115573		4	- 6	p 14-8-13	
					Line Total:	\$96.00
2	115850	D3574-2 CABIN FLOOR PROTECTOR	8/13/2014	3.00	\$27.78	\$83.34

Yes 8/13/2014

Line Total:

\$83.34

Note:

AS PER DWG D3574-2 REV. B

B115850

T.P.I. INDUSTRIES INC.

148 GOODFELLOW DELSON, QUÉBEC J5B 1V4 CANADA

Tel: (450) 633-0484 Fax: (450) 633-0879

Tracking No.:

Packing Slip

Packing Slip No.:

6222

Date:

2014-08-11

Page:

1

Sold to:			Ship to:	
	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario Canada	K6A 1K7	Da Mi 12 Ha	art Aerospace chael Grégoire 70 Aberdeen awkesbury, Ontario K6A 1K7 anada
Order No.:	100807		Sold By:	JONATHAN LESSARD
Shipped B	By:		Ship Date:	2014-08-11

. Item:No.	e Unit)	রব্যবিয়াকে			୍ଥ ପାଲା	ij
574-1	Chaque	d3574-1						•
574-2	Chaque	d3574-2						
574-5	Chaque	d3574-5	3 .					
574-6 57 5-1	Chaque	d3574-6		and Market and the second	7a + 1	wyg i di		
575-2	Chaque	d3575-1 d3575-2						
575-2 575-5	Chaque Chaque	d3575-5	•					
575-6	Chaque	d3575-6	A AR A GARAGE A SERVICE	the first the second of				
878-1	Chaque	d3878-1					j	
879-3	Chaque	d3879-3						
889-1	Chaque	d3889-1						
890-1	Chaque	d3890-1			•			
891-1	Chaque	d3891-1				. •	•	
891-2	Chaque	d3891-2						
933-1	Chaque	d3933-1		•				-
933-2	Chaque	d3933-2			•			
935-1	Chaque	d3935-1						
935-2	Chaque	d3935-2						
935-3	Chaque	d3935-3				·		
935-4	Chaque	d3935-4	• •				"	
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